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METHOD OF MOLDING BOARDLIKE RESIN

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ABSTRACT

PURPOSE: To mold boardlike resin with a large number of intermittent protrusions in arbitrary length, by pressing beads of the boardlike resin on which the continuous protruding line has been formed in a longitudinal direction by an extrusion molding machine by an unevenness molding machine during an uncured state of the boardlike resin.

CONSTITUTION: A core plate 1 is inserted into an extrusion molding equipment 6 by a pressing-in roller 5. Vinyl chloride 2 in a hopper 7 is softened and melted within a barrel 8, with which the core plate 1 is coated. When the core plate 1 is extruded through the extrusion molding equipment 6, a bead 9 is formed continuously by a die 10 in a longitudinal direction on the top 3a of boardlike resin 3 obtained by coating the core plate 1 with the vinyl chloride 2. The boardlike resin 3 extruded through the extrusion molding machine 6 is conveyed to an unevenness molding machine 11 during uncured state of the same and receives vertical pressure by an upper rubber belt 12 and lower rubber belt 13 of the unevenness molding machine 11. In this instance, a protrusion 12a of the upper rubber belt 12 presses the beads 9 at every other constant intervals and forms a protrusion 4. With this construction, the boardlike resin having a large number of the protrusions on the top or the top and bottom can be molded in arbitrary length.

